Work Order ID 115380

Friday, March 28, 2014 9:05:18 AM

115380

RUSH April 4th

Item ID: D4410-9 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Trigger

Start Date: 3/28/2014 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 4/4/2014 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Approvals: **Process Plan:** MF. **Date:** 14-3-28 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D4410	REV B

100 0.00

100

Mill Conv

Conventional Milling Machine

Memo 0.00

FACE MATERIAL TO .250" +.000/-.005"

8 14/03/28 _____

mm/D.a

105 0.00

105

Waterjet

FLOW CNC Waterjet

Memo 0.00

CUT AS PER DWG

DWG REV: D4410

PROG REV: Rev.B

DEBURR

8 14/03/28 _____

mm/D.a

Work Order ID 115380

115380

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Revision ID: **Stop** *NS2*

Item Name: Trigger

Start Date: 3/28/2014 **Start Qty:** 8.00 *8*

Required Date: 4/4/2014 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC2- Inspect parts off machine FAI/FAIB	0.00				8	Ø		14/03/28
110									
QC	**Memo**	0.00							
Quality Control									
120		0.00				8	Ø		MH 14/03/29
120									
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	1- FACE TRIGGER IF NECESSARY PER DWG 2- MILL .125" RAD AND DRILL & TAP AS PER DWG DEBURR								
125	QC2- Inspect parts off machine FAI/FAIB	0.00				8	Ø		MH 14/03/29
125									
QC	**Memo**	0.00							
Quality Control									

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Item ID: D4410-9 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Trigger

Start Date: 3/28/2014 **Start Qty:** 8.00 *8*

Required Date: 4/4/2014 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				8	0		14-04-02
130									
QC	**Memo**	0.00							
Quality Control									
170	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
170									
Outsource4	**Memo**	0.00							
Outsource process - Anodize	Issue P/O: 23623								
	Black Anodize as per Dwg D4410								
180	Receive & Inspect for Damage & Mat'l Certs	0.00							
180									
Packaging	**Memo**	0.00							
Packaging									

CL 14/04/03 (8)

14/4/8 (8)

Item ID: D4410-9 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Trigger
Start Date: 3/28/2014 **Start Qty:** 8.00 *8*
Required Date: 4/4/2014 **Req'd Qty:** 8.00 *8*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00 DAS 27 9-89 14/4/8				8			
190 QC Quality Control	**Memo**	0.00							
220	Identify as per dwg & Stock Location: ST105	0.00							
220 Packaging Packaging	Packaging **Memo**	0.00				8X	DAS 28 9 89 APR 0 8 2014		
230	QC21- Final Inspection - Work Order Release	0.00							
230 QC Quality Control	**Memo**	0.00				MLS 14-04-09			

MF 4-4-08

Picklist Print

Friday, March 28, 2014 9:05:15 AM

Work Order ID: 115380 *115380*

Parent Item: D4410-9 *D4410-9*

Parent Item Name: Trigger

Start Date: 3/28/2014 **Required Date:** 4/4/2014

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X02.500		Purchased	No				f	27.7500		1			

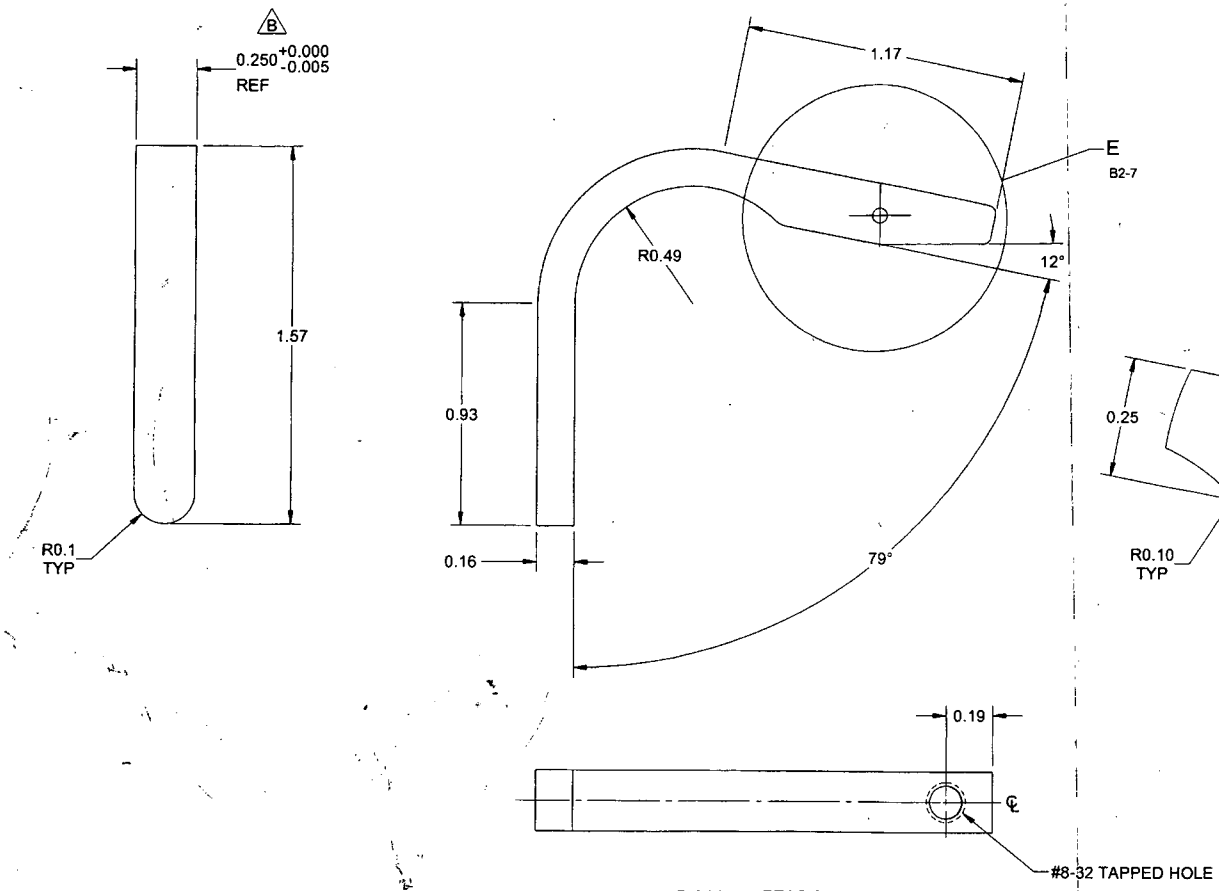
M6061T6B0.250X02.500 **

6061-T6 Bar 0.25 x 2.50

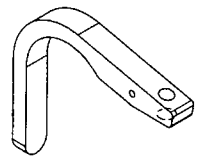
mm | 14/03/28

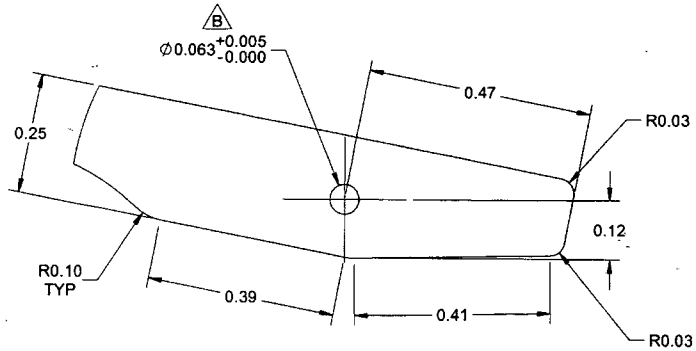
Location	Loc Qty	Loc Code	
MAT049	27.75		
106652	4		
121192	0.75		
124443	3		
M128247	20		0.26

408
408



D4410-9 TRIGGER





DETAIL E

D4-7

#115380
14-3-28

RELEASED
2012 -09- 28

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.250
2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.01 lbs

DESIGN	BC	DART AEROSPACE USA, INC. KENT, WA
DRAWN	BC	
CHECKED		DRAWING NO. D4410 REV. B
MFG. APPR.		SHEET 9 OF 12
APPROVED		TITLE CO-PILOT COLLECTIVE HEAD SCALE NTS
DE APPR.		
DATE 12.07.30		

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DART AEROSPACE LTD	Work Order:	115380
Description: Trigger	Part Number:	D4410-9
Inspection Dwg: D4410 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.93	+/-0.030	093	✓		JML-05	
0.16	+/-0.030	0.16	✓			
1.17	+/-0.030	1.17	✓			
0.250	+/-0.010	0.250	✓			
Ø.063	+.005/-.000	.0645	✓		MH-04	Caliper
0.47	+/-.03	.475	✓			
0.19	±.03	.19	✓			
0.12	+/-.03	.125	✓			
0.250	+.000 -.005	.248	✓			
Ø.136 (8-32)	+.006 -.001	.138	✓			

Measured by:	mm / MH	Audited by:		Preliminary Approval:	
Date:	14/03/28 14/05/22	Date:	14-04-02	Date:	

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23622

Purchase Order Date 4/3/2014
PO Print Date 4/8/2014

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	613-446-4544	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)
Ship Acct:			

Line Nbr	Reference / Vendor Part Number / Line Comments / Delivery Comments	Description/ Mfg ID	Req Date/ Taxable / Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
115380		D4410-9 TRIGGER	4/8/2014 Yes 4/8/2014		8.00	$10.00	$80.00
	FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB/IC/II/IIB CLASS 2 PLEASE ADVISE DELIVERY RUSH ORDER						
						Line Total:	**$80.00**
115435		D4410-043 CO-PILOT COLLECTIVE HEAD	4/8/2014 Yes 4/8/2014		2.00	$10.00	$20.00
	FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB/IC/II/IIB CLASS PLEASE ADVISE DELIVERY RUSH ORDER						
						Line Total:	**$20.00**

Note:

A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62969 Date: 04-Apr-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200 Fax: 613-632-1185

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200 Fax: 613-632-1185

Terms	Ship Via

Quantity	Description
1 lot	Part: ASST Rev: 8 PCS D4410-9 2 PCS D4410-043 BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 MINIMUM RUN (100.00$) Job: 20140205 PO: 23622 Line:

Certificate of Conformance

A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE : 4/4/14

CERTIFIED SIGNATURE : _____

RECEIVER SIGNATURE : _____